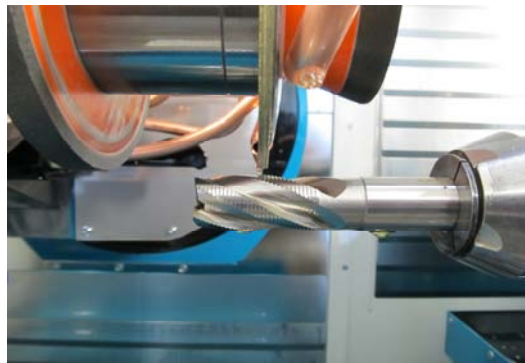
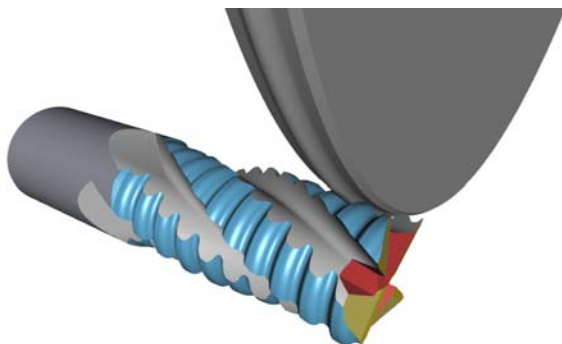


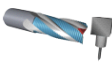
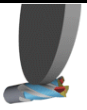
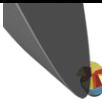
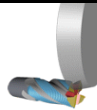
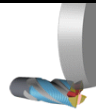
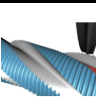








HSS Roughing Endmill Ø20 Z4

A01-800

Production of HSS Roughing Endmills with dressable CBN-formwheels can be done very effective. The dressing of the formwheel is executed each 4 to 8 endmills. The lead of the roughing profile is 4 mm.



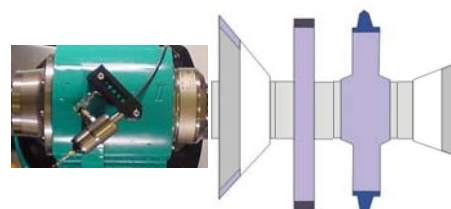
1. Cycletime for Production

| | | | | | | | | |
|--------------------|---|---|---|---|---|--|---|---|
| Workpiece: | Ø 20 mm, Z 4, Length of cutting edge 38 mm, Helix 32°, lead 4 mm | | | | | | | |
| Material | HSS | | | | | | | |
| Operations |  |  |  |  |  |  |  |  |
| Feed [mm/Min] | 2000 | 80 | 100 | 60 | 80 | 400 | 100 | 9000 |
| Power [kW] | | 12 | 3 | 3 | 2 | 2 | 2 | 1 |
| Cutting feed [m/s] | | 36 | 32 | 32 | 32 | 35 | 50 | |
| Used wheels | |  |  |  |  |  |  | |
| Grinding time [s] | 6 | 178 | 56 | 68 | 55 | 85 | 45 | 26 |
| Total cycle time | 8 Min 40 | | | | | | | |

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

| | |
|---|----------------|
| 1 | 1A1 Ø125 B126 |
| 2 | 12V9 Ø125 B126 |
| 3 | 11V9 Ø75 B126 |
| 4 | DXF Ø125 B126 |



2 1 4 3

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR Coolant: Synthetic Oil, pressure 10 bar
Control: Fanuc 310i Software: Quinto 5
Accessories:

Responsible engineer: OP. 14.4.11

www.schneeberger.ch

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Subsidiaries in: France, Deutschland, Italia, United States, UK, China